

WORK ORDER 2008-32

Date opened: 10 November 2008

Project: Quick Release Cargo Basket Assembly and Step Assembly
Type: MD600NBatch Quantity: 1 Complete Basket Assembly (82810-01) with mounting parts
1 Step AssemblyApproval: Pending 5409-1
Drawing List: DCL828 / DCL829

Fabrication and Assembly Drawing(s)	Description
82810, Rev. 0	Basket Ass'y
82811, Rev. 0	Basket Body Ass'y
82812, Rev. 0	Basket Lid Ass'y
82815, Rev. 0	Down Tube Assembly
82830, Rev. 0	Cargo Hook Pad
82831, Rev. 0	Strut Assemblies
82832, Rev. 0	Down Tube Fabrication
36255, Rev. 1	Handle Installation
36261, Rev. 4	Handle Bar Ass'y
36262, Rev. 1	Handle Bracket Ass'y
82910, Rev. 0	Step Assembly

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

List all non-conformities raised: _____

Inspector Signature: Jeff Clark Date: April 9/09

Welder Signature: _____ Date: _____

Drawing: 82810 Revision 0
 Assembly: 82810-01 Cargo Basket Ass'y (Quick-Release, Short)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	82810-01	Cargo Basket Assembly			
1	82811-01	Basket Body Assembly	Below		
1	82812-01	Basket Lid Assembly	Below		
1	36255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace		
1	MS20001P4	Piano Hinge			
1	82827-01	Placard	0.063 Sheet, 6061-T6 Aluminum		
3	49205-14	Bumper	Argus Industries Bumper		
A/R	CR3213-4-02	Cherry Rivet			
4	40088-14	Fitting	Ancra		
4	AN960-616	Washer			
1	AN3-15A	Bolt			
1	AN3-17A	Bolt			
4	AN960-10	Washer			
2	AN970-3	Washer			
2	MS21044N3	Nut			

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	HR3213-4-02 Rivets		
Final Inspection	Drawing 82810			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 82811 Revision 0
 Assembly: 82811-01 Basket Body Ass'y (Quick-Release, Short, 57.25" long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	82811-01	Basket Body Assembly			
3	49210-02	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube		
2	82820-01	Attachment Hoop	4130 Steel, 1 x 0.065 & 1/2" x 0.035 Sqr. Tube		
A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube		
A/R		Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube		
1	36262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod		
A/R	3/4-16F	Mesh	Expanded carbon steel		

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 82811			
Final Inspection	Drawing 82811			

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Drawing: 82812 Revision 0
Assembly: 82812-01 Basket Lid Ass'y (Quick-Release, Short, 57.25" long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	82812-01	Basket Lid Assembly			
A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube		
1	49216-01	Spacer	1018 Steel, 1/2" Rod		
1	36262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet		
A/R	3/4-16F	Mesh	Expanded carbon steel		

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 82812			
Final Inspection	Drawing 82812			

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Drawing: 36255 Revision 1
Assembly: 36255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36255-01	Handle Installation			
1	36261-01	Handle Bar Assembly	Below		
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire		
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia		
2	AN3-14A	Bolt			
4	AN960-10	Washer			
2	MS21044N3	Nut			


Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 36255		<i>JE</i>	

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Drawing: 36261 Revision 4
Assembly: 36261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube		
2	36271-01	Lever	304 Stainless, 0.105 Sheet		
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube		
2	MS20615-4M3	Rivet			


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36261			

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Drawing: 36262 Revision 1
Assembly: 36262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
1 Total	36261-01	Handle Bracket Assembly			
1	36272-01	Basket Bracket	321 Stainless, 0.050 Sheet		
2	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet		
2	36275-02	Support	304 Stainless, 5/16" Rod		


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36262			

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Drawing: 82815 Revision 0
Assembly: 82815-01 Down Tube Ass'y

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	82815-01	Down Tube Assembly			
1	82832-01	Down Tube	Below		
2	69830-21	Stop	6061-T6 Aluminum, 5/8 Rod		
1	69830-22	Knob	6061-T6 Aluminum, 3/4 Rod		
1	82815-05	Knob	6061-T6 Aluminum, 1.25 Rod		
2	69830-23	Spring			
2	#10-32	Screw	Stainless Steel		
2	MS21044C3	Nut			
1	AN45-7A	Eye Bolt			
1	AN960-516	Washer			
1	MS21044N5	Nut			

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 82815			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 82830, Revision 0; 82831, Revision 0

Assembly: 82830-01 Cargo Hook Pad; 82831-01 Forward Strut Assembly; 82831-02 Aft Strut Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	82830-01	Cargo Hook Pad	6061-T6 Aluminum, 1.5 x 2.5 Bar		
2	AN45-7A	Eye Bolt			
2	AN960-516	Washer			
2	MS21044N5	Nut			
1 Total	82831-01	Forward Strut Assembly			
1	82831-03	Tube	4130 Steel, 5/8 x 0.035 Rnd. Tube		
2	AN490HT10P	Rod End			
2	AN665-46R	Threaded Rod End			
2	AN316-5R	Check Nut			
1 Total	82831-02	Aft Strut Assembly			
1	82831-03	Tube	4130 Steel, 5/8 x 0.035 Rnd. Tube		
2	AN490HT10P	Rod End			
2	AN665-46R	Threaded Rod End			
2	AN316-5R	Check Nut			


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 82831			
Final Inspection	Drawing 82830, 82831			

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Drawing: 82832 Revision 0
Assembly: 82832-01 Down Tube

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	82832-01	Down Tube			
1	82832-02	Tube	304 Stainless Steel, 1 x 2 x 0.12 Tube		
1	82832-03	Pin	304 Stainless Steel, 3/4 Rod		
1	82832-04	Spacer	304 Stainless Steel, 3/4 Rod		
2	69830-07	Block	304 Stainless Steel, 1/8 x 1/4 Rod		
1	69830-19	Cap	321 Stainless Steel, 0.025 Sheet		
2	69830-11	Guide	304 Stainless Steel, 3/4 x 0.065 Tube		

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 82832			

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Drawing: 80010 Revision 1
Assembly: 80010-7475 Step Assembly
Batch Quantity: 5 sets

Qty	Part #	Description	Material	P.O./W.O.	Checked
1	82910-01	Step Assembly	Step Extrusion	8021	
1	80021-01	Step Support	6061-T6 Aluminum, 3.5 x 1 bar	8089	

Processes	Per	Mat'ls Used	Initials
Welding	AMS2685C	ER4043 Rod	
Powder Coating			JC.

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Oceanview

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket Part #: 82810-01
Approval #: SH09-1 Serial #: 82801-01
WO #: 2008-32 Quantity: 1
Eligibility: McDonnell Douglas MD600N Work Status: Manufactured
Remarks: _____

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

April 9/09 Date Jeff Clark Inspector's Signature

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Down Tube Assembly Part #: 82815-01
Approval #: SH09-1 Serial #: --
WO #: 2008-32 Quantity: 2
Eligibility: McDonnell Douglas MD600N Work Status: Manufactured
Remarks: _____

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AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Cargo Hook Pad Part #: 82830-01
Approval #: SH09-1 Serial #: --
WO #: 2008-32 Quantity: 1
Eligibility: McDonnell Douglas MD600N Work Status: Manufactured
Remarks: _____

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AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Forward Strut Part #: 82831-01
Approval #: SH09-1 Serial #: --
WO #: 2008-32 Quantity: 1
Eligibility: McDonnell Douglas MD600N Work Status: Manufactured
Remarks: _____

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April 8/09
Date

Jeff Clark
Inspector's Signature

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AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Aft Strut Part #: 82830-02
Approval #: SH09-1 Serial #: --
WO #: 2008-32 Quantity: 1
Eligibility: McDonnell Douglas MD600N Work Status: Manufactured
Remarks: _____

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April 8/09
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AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Step Part #: 82910-01
Approval #: SH09-1 Serial #: --
WO #: 2008-32 Quantity: 1
Eligibility: McDonnell Douglas MD600N Work Status: Manufactured
Remarks: _____

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Date

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